

Date: Thursday, 5/4/2006 11:20:25 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BRACKET & CLAMP ASSEMBLY
<b>Job Number</b> :	27002		
<b>Estimate Number</b> :	12255		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3481043
<b>This Issue</b> :	5/4/2006	<b>Drawing Number</b> :	D3481 REV A
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	N/A	<b>Drawing Revision</b> :	A
<b>Previous Run</b> :	26294	<b>Material</b> :	N/A
<b>Written By</b> :	See Comment Below	<b>Due Date</b> :	5/28/2006
<b>Checked &amp; Approved By</b> :	06.05.0	<b>Qty:</b>	3 Um: Each
<b>Comment</b> :	Est Rev: A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D34813	Angle bracket
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3	Bracket	B27027

2.0	QS20056S	CLAMP
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	QS20056S	Clamp	M100202

SB 06/05/18 (2)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

2-Spot Weld as per Dwg D3481

SB 06/05/18 (2)

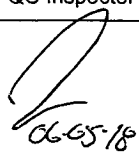
4.0	QC5811	WELD INSPECTION
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**Comment:** WELD INSPECTION

06.05.18 (2)

(170)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-05-18	40	QC 5411 for spot weld. permanent change.					 06-05-18	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/05/19

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 5/4/2006 11:20:26 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET & CLAMP ASSEMBLY

Job Number: 27002

Part Number: D3481043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/05/18

(2)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SP 06/05/19

(2)

Job Completion



11 06/05/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

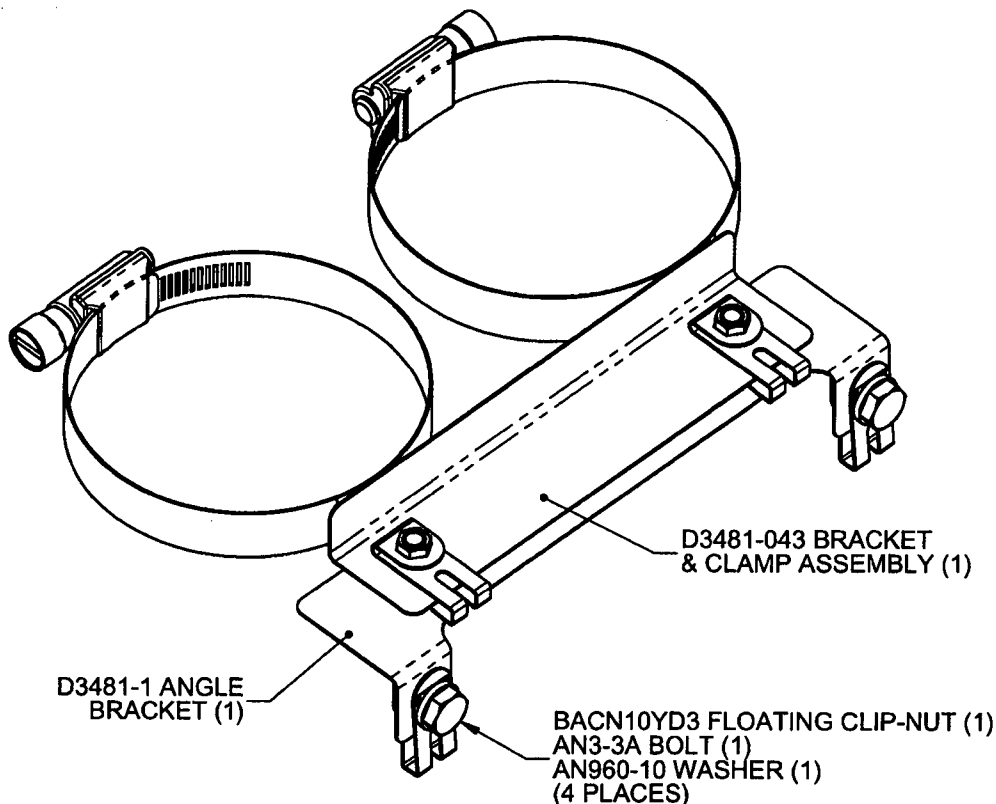
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3481</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>SHUT-OFF VALVE BRACKET</b>	SCALE 2:3
A	06.01.23	NEW ISSUE	

*[Signature]* 06.04.03



### **D3481-041 SHUT-OFF VALVE BRACKET**

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

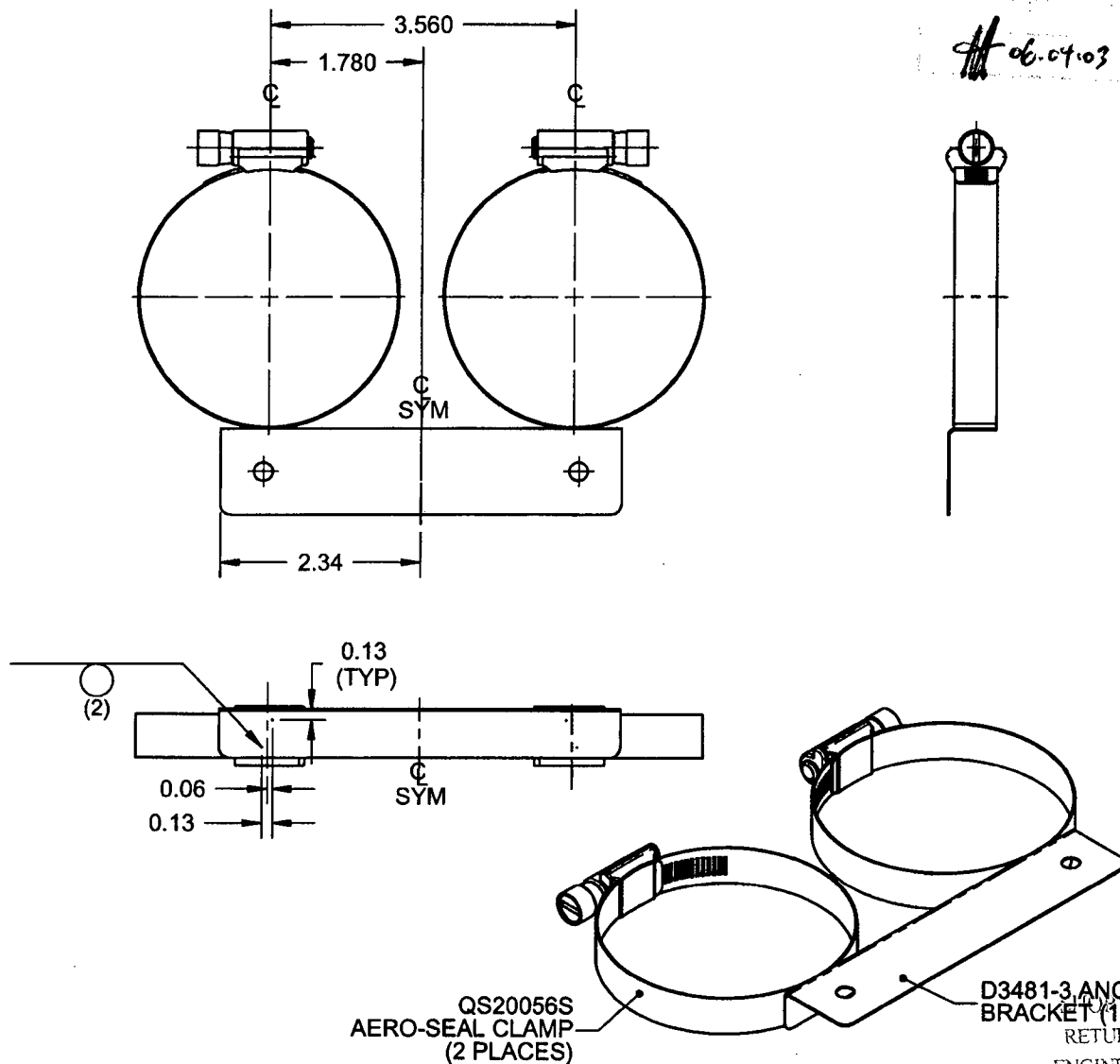
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



### D3481-043 BRACKET & CLAMP ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

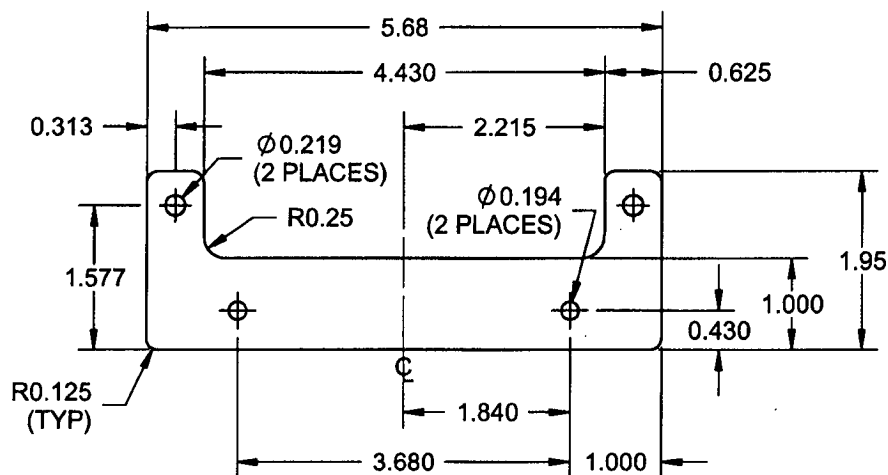
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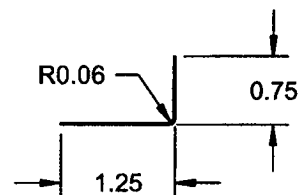
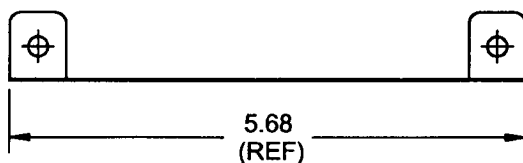
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

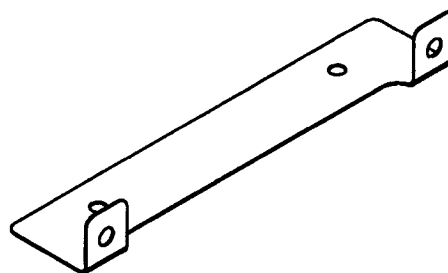


**D3481-1F FLAT PATTERN**



**D3481-1 ANGLE BRACKET**

*[Signature]* 06.04.03



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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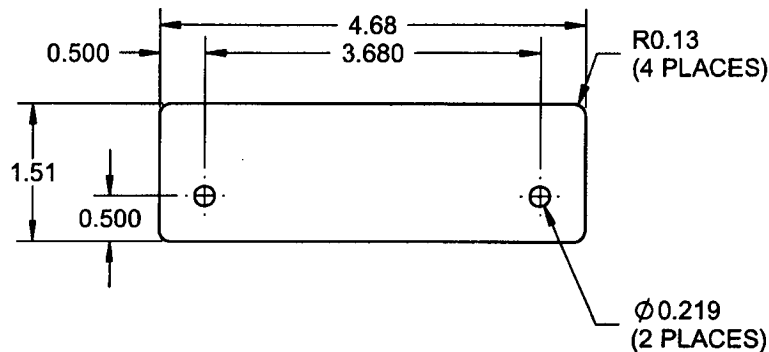
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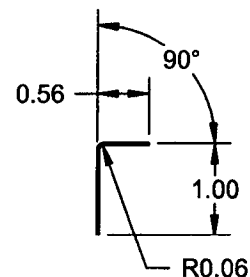
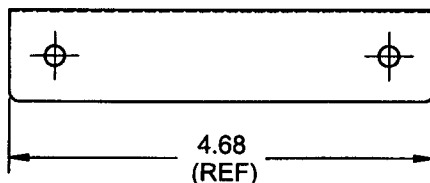


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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2

*[Signature]* 06.04.03



**D3481-3F FLAT PATTERN**



**D3481-3 ANGLE BRACKET**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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